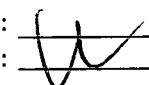
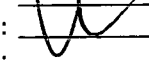


Date: Thursday, 15/05/2008 3:01:19 PM
 User: Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	REWORK
Job Number :	39306		
Estimate Number :	10804		
P.O. Number :		Part Number :	D350636014
This Issue :	15/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	ECN1191
First Issue :	1/1	Project Number :	
Previous Run :	39305	Drawing Revision :	
	Type :	Material :	
	SKIDTUBES	Due Date :	22/05/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :			
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 PULL FROM STOCK:

1 X D350-636-014 B 37574 CHG 003

2.0	D350636014	Skidtube RH
-----	------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Skidtube

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 REMOVE FROM FRONT OF TUBE:

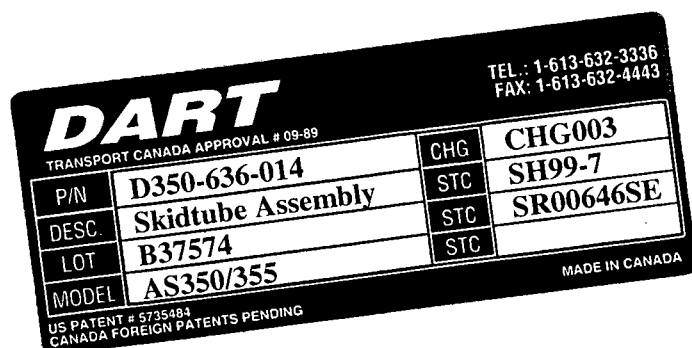
1 X D3535-13 WEARSHOE B 36423
 1 X D3536-13 GASKET B 36635
 1 X D3537-1 WEARPAD B 38254

REMOVE FROM BACK OF TUBE:

1 X D3535-35 WEARSHOE B 36425
 1 X D3536-35 GASKET B 37352
 1 X D3537-1 WEARPAD B 38254
 2 X NAS1515H8L - DISCARD
 1 X AN960C816L - DISCARD

ADD TO FRONT OF TUBE PER DRWG DSI9413 REV.A

1 X D3794-1 GASKET B 39279
 1 X D3793-1 WEARSHOE B 39277
 1 X D3791-1 WEARPLATE B 39276
 4 X D3672-1 WASHER B 39275



PL 08/06/03 (1)

Date: Thursday, 15/05/2008 3:01:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 39306

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 X AN526C1032R10 SCREW *m108062*

NOTE: USE EXISTING HARDWARE TO FASTEN NEW WEARPLATES

ADD TO BACK OF TUBE PER DRWG DSI9413 REV.A

1 X D3794-3 GASKET B *39361*

1 X D3793-3 WEARPLATE B *39479*

4 X D3672-1 WASHER B *39275*

4 X AN526C1032R18 *m108079*

NOTE: USE EXISTING HARDWARE TO FASTEN NEW WEARPLATES

m21083-C8
m107756 *x1*

FL 08/06/03 ①

4.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

FL

5.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe

FL

6.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate

FL

7.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

FL

8.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe

FL

9.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Phenolic Washer

FL 08/06/03 ①

Date: Thursday, 15/05/2008 3:01:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 39306

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

FL

11.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

FL 08/06/03

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 08 06 04 ①

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT
ORIGINAL KIT WITH TUBE

S 080606/05 ②

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP CHG 004
NEW LABELS REQUIRED

JLD 08.5.02

③

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09

Job Completion



MF 08-06-06
CL

37574

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

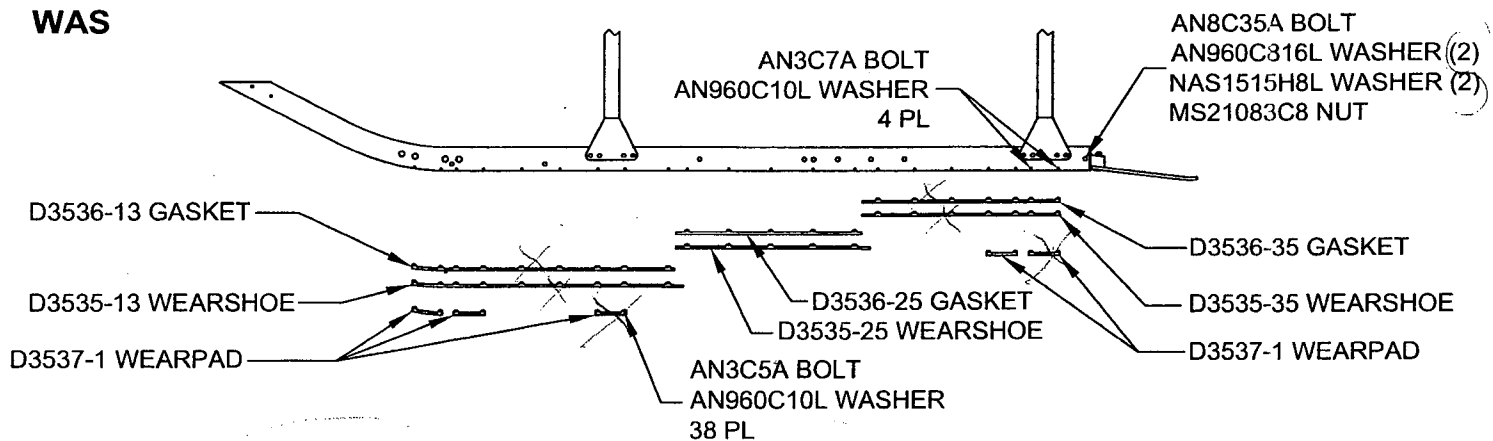
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

WAS



NOW

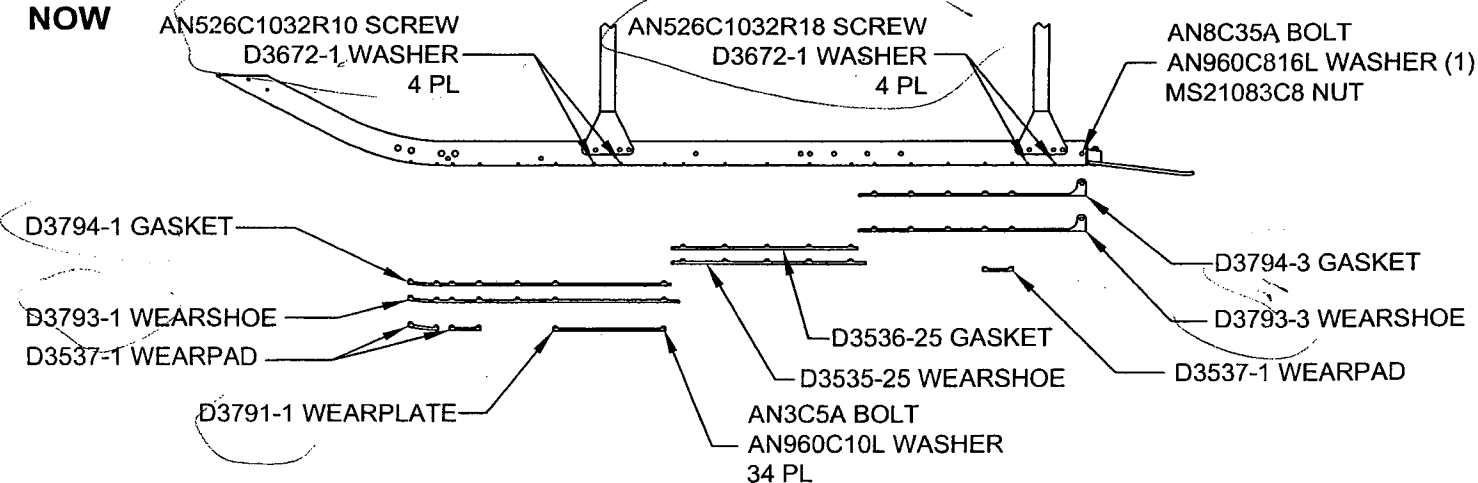


FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011
(LOCATION OF AN526C1032RXX SCREWS ARE NOT TO BE USED TO MOUNT WEARSHOES)

PRELIMINARY ISSUE

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Date: Friday, 23/05/2008 1:21:39 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37574	Customer	: Dart Helicopters Services
Estimate Number	: 10268	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636014
Complete Date	: 07/04/2008 12:47:31	DWG Number	: D2750 REV E
Rev.	: E		

DUE DATE		ORDERED	DELIVERED
10/03/2008	1	1	

2.0 D26003BENT-Extrusion Bent		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
18/03/2008	ELLI01: Elliott, Barclay	D26003BENT	1.000
			COST
			\$22.40
			Lot # 35527 Qty. 1
Subtotal:		QTD: 0 CTD: 1	\$22.40

3.0 D2744-Cap		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
19/03/2008	ELLI01: Elliott, Barclay	D2744	1.000
			COST
			\$3.10
			Lot # 33996 Qty. 1
Subtotal:		QTD: 0 CTD: 1	\$3.10

4.0 SKIDTUBES 1		Internal Operation	
DATE	EMPLOYEE	TYPE	Qty
18/03/2008	ELLI01: Elliott, Barclay	Run	0.000
19/03/2008	RAIN01: Rainey, Jamie	Run	1.000
19/03/2008	ELLI01: Elliott, Barclay	Run	0.000
24/03/2008	RAIN01: Rainey, Jamie	Run	1.000
			Time(hrs)
			3.01
			0.60
			0.45
			0.80
			COST
			\$49.54
			\$9.88
			\$7.41
			\$13.17
			MTime(hrs)
			3.01
			0.60
			0.45
			0.80
			Mach.Cost
			62.42
			12.45
			9.34
			16.59
Subtotal:		QTD: 2 CTD: 0	4.86
			\$180.80

7.0 HAND FINISHING1		Internal Operation	
DATE	EMPLOYEE	TYPE	Qty
24/03/2008	RAIN01: Rainey, Jamie	Run	1.000
			Time(hrs)
			0.23
			COST
			\$3.79
			MTime(hrs)
			0.46
			Mach.Cost
			14.69
Subtotal:		QTD: 1 CTD: 0	0.23
			\$18.48

9.0 D2739-350 I Beam		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
24/03/2008	RAIN01: Rainey, Jamie	D2739	1.000
			COST
			\$41.81
			Lot # 36871 Qty. 1
Subtotal:		QTD: 0 CTD: 1	\$41.81

10.0 D34901-Cross Bolt Spacer		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
25/03/2008	ELLI01: Elliott, Barclay	D34901	4.000
			COST
			\$7.08
			Lot # 33824 Qty. 4
Subtotal:		QTD: 0 CTD: 4	\$7.08

11.0 D34905-Cross Bolt Spacer		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
25/03/2008	ELLI01: Elliott, Barclay	D34905	4.000
			COST
			\$16.47
			Lot # 32597 Qty. 4
Subtotal:		QTD: 0 CTD: 4	\$16.47

12.0 D2743-Crossbolt Spacer		INVENTORY ITEM	
DATE	EMPLOYEE	TYPE	Qty
25/03/2008	ELLI01: Elliott, Barclay	D2743	8.000
			COST
			\$15.32
			Lot # 36030 Qty. 8
Subtotal:		QTD: 0 CTD: 8	\$15.32

Date: Friday, *23/05/2008 1:21:39 PM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37574	Customer	: Dart Helicopters Services
Estimate Number	: 10268	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636014
Complete Date	: 07/04/2008 12:47:31	DWG Number	: D2750 REV E
		Rev.	: E

13.0 SKIDTUBES 1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
24/03/2008	RAIN01: Rainey, Jamie	Run	1.000	0.75	\$12.35	0.76	15.76
25/03/2008	ELLI01: Elliott, Barclay	Run	0.000	1.41	\$23.21	1.41	29.24
26/03/2008	RAIN01: Rainey, Jamie	Run	1.000	1.06	\$17.45	1.06	21.99
Subtotal:			QTD:	2 CTD:	0	3.22	\$120.00

16.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
26/03/2008	ROQU01: Roquebrune, Benoit	Run	1.000	0.26	\$3.58	0.26	6.95
Subtotal:			QTD:	1 CTD:	0	0.26	\$10.53

17.0 POWDER COATING Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
27/03/2008	ROQU01: Roquebrune, Benoit	Run	1.000	0.33	\$4.54	0.66	17.62
Subtotal:			QTD:	1 CTD:	0	0.33	\$22.16

19.0 ALS41032225-Insert INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	ALS41032225	42.000		\$3.98		Lot # 100489 Qty. 42
Subtotal:			QTD:	0 CTD:	42	\$3.98	

21.0 D2745-Bushing INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	D2745	8.000		\$44.51		Lot # 34817 Qty. 8
Subtotal:			QTD:	0 CTD:	8	\$44.51	

22.0 D353513-Wearshoe INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	D353513	1.000		\$9.01		Lot # 36423 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$9.01	

23.0 D353525-Wearshoe INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	D353525	1.000		\$16.39		Lot # 36424 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$16.39	

24.0 D353535-Wearshoe INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	D353535	1.000		\$11.98		Lot # 36425 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$11.98	

25.0 D353613-Gasket INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/04/2008	LAUG01: Laughren, Gary	D353613	1.000		\$1.89		Lot # 36635 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$1.89	

Date: Friday, 23/05/2008 1:21:39 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37574	Customer	: Dart Helicopters Services
Estimate Number	: 10268	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636014
Complete Date	: 07/04/2008 12:47:31	DWG Number	: D2750 REV E
		Rev.	: E

26.0 D353625-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D353625	1.000		\$1.42	Lot # 36636 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$1.42	

27.0 D353635-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D353635	1.000		\$1.72	Lot # 37352 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$1.72	

28.0 D35371-Wearpad INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D35371	5.000		\$123.05	Lot # 38254 Qty. 5
Subtotal:			QTD: 0	CTD: 5	\$123.05	

29.0 D36311-Washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D36311	8.000		\$0.61	Lot # 34276 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$0.61	

30.0 D3488042-Blade Fitting Assembly, RH INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D3488042	1.000		\$206.57	Lot # 26839 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$206.57	

31.0 D3492041-Plug Assembly INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D3492041	8.000		\$22.29	Lot # 36902 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$22.29	

32.0 D3492045-Plug Assembly INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	D3492045	8.000		\$28.52	Lot # 33435 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$28.52	

33.0 AN3C5A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN3C5A	38.000		\$13.34	Lot # 106780 Qty. 38
Subtotal:			QTD: 0	CTD: 38	\$13.34	

34.0 AN3C6A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN3C6A	4.000		\$1.75	Lot # 105300 Qty. 4
Subtotal:			QTD: 0	CTD: 4	\$1.75	

Date: Friday, 23/05/2008 1:21:39 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37574	Customer	: Dart Helicopters Services
Estimate Number	: 10268	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636014
Complete Date	: 07/04/2008 12:47:31	DWG Number	: D2750 REV E
		Rev.	: E

35.0 AN3C7A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN3C7A	4.000		\$1.60	Lot # 105906 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$1.60

36.0 AN6C44A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN6C44A	4.000		\$123.27	Lot # 106662 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$123.27

37.0 AN8C35A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN8C35A	1.000		\$39.88	Lot # 106896 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$39.88

38.0 AN960C10L-washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
07/04/2008	FAUT01: Fauteux, Melanie	AN960C10L	14.000		\$0.82	Lot # 107008 Qty. 14
Subtotal:		QTD:	0	CTD:	14	\$0.82

39.0 AN960C816L-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	AN960C816L	2.000		\$0.27	Lot # 106513 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.27

40.0 MS210436-NUT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	MS210436	4.000		\$6.80	Lot # 103693 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$6.80

41.0 MS21083C8-NUT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	MS21083C8	1.000		\$1.20	Lot # 106431 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$1.20

42.0 NAS1515H3L-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	NAS1515H3L	4.000		\$0.34	Lot # 106516 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$0.34

43.0 NAS1515H8L-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
03/04/2008	LAUG01: Laughren, Gary	NAS1515H8L	2.000		\$0.41	Lot # 107581 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.41

Date: Friday, 23/05/2008 1:21:40 PM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37574	Customer	: Dart Helicopters Services
Estimate Number	: 10268	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636014
Complete Date	: 07/04/2008 12:47:31	DWG Number	: D2750 REV E
		Rev.	: E

44.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
27/03/2008	GREG01: Gregory, Marc	Run	0.000	2.30	\$30.87	2.30	59.89
03/04/2008	LAUG01: Laughren, Gary	Run	1.000	1.62	\$25.19	1.62	75.32
Subtotal:			QTD: 1 CTD: 0	3.92	\$191.27		

47.0 D2741-Blade, 350 Skidtube INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	D2741	1.000		\$230.42		Lot # 35435 Qty. 1
Subtotal:			QTD: 0 CTD: 1		\$230.42		

48.0 AN960C816L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	AN960C816L	2.000		\$0.27		Lot # 107520 Qty. 2
Subtotal:			QTD: 0 CTD: 2		\$0.27		

49.0 MS21083C8-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	MS21083C8	2.000		\$2.40		Lot # 106431 Qty. 2
Subtotal:			QTD: 0 CTD: 2		\$2.40		

50.0 AN8C21A-BOLT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	AN8C21A	2.000		\$19.78		Lot # 105160 Qty. 2
Subtotal:			QTD: 0 CTD: 2		\$19.78		

51.0 NAS1515H8L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	NAS1515H8L	2.000		\$0.41		Lot # 107581 Qty. 2
Subtotal:			QTD: 0 CTD: 2		\$0.41		

52.0 D34931-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/04/2008	SAUV02: Sauve, Amy	D34931	2.000		\$21.71		Lot # 36034 Qty. 2
Subtotal:			QTD: 0 CTD: 2		\$21.71		

		TIME	COST
	Machine Time:	13.39	\$342.26
	Labor:	12.82	\$200.98
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$1042.79
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$1586.03

COST PER UNIT:		\$1586.03
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